

Date: Tuesday, 9/11/2007 10:57:54 AM  
 User: Chantal Lavoie

## Process Sheet



Customer :  
 Job Number : 34547  
 Estimate Number : 12964  
 P.O. Number :  
 This Issue : 9/11/2007 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : / / Type : SMALL / MED FAB  
 Previous Run : 33718  
 Written By :  
 Checked & Approved By :  
 Comment : Est Rev:A New Issue 07-07-20 JLM Verified By:EC

Drawing Name : STIFFNER  
 Part Number : D36431  
 Drawing Number : D3643 UNDER REVIEW  
 Project Number : N/A  
 Drawing Revision : U/R  
 Material :  
 Due Date : 9/18/2007 Qty: 0 Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M2024T3S040 2024-T3 .040 sheet



Comment: Qty.: 0.1549 sf(s)/Unit Total: 0.0000 sf(s)

2024-T3 .040 sheet

Batch: M105225 HB 07-09-17

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3643

Dwg Rev: A HB 07-09-17

Prog Rev: A

2-Deburr if necessary HB 07-09-17

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3643

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_















QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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## Process Sheet

Customer:		Drawing Name: STIFFNER	
Job Number: 34547		Part Number: D36431	
Job Number:			
Seq. #:	Machine Or Operation:	Description :	
6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
			
Comment: SMALL & MEDIUM FAB RESOURCE 1 C'sink as per Dwg D3643			
7.0	QC5	INSPECT WORK TO CURRENT STEP	
			
Comment: INSPECT WORK TO CURRENT STEP			
8.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
			
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1			
9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION	
			
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION			
10.0	PACKAGING 1	PACKAGING RESOURCE #1	
			
Comment: PACKAGING RESOURCE #1 Identify with P/N and B/N using a permanent fine point marker, then stock Location: <u>7/10/15</u>			
11.0	QC21	FINAL INSPECTION/W/O RELEASE	
			
Comment: FINAL INSPECTION/W/O RELEASE			
Job Completion			
<p>U 07.10.16</p> <p>POSITIVE RECALL EFFECTIVE 07.09.11 AUTH U RELEASED U DATE 07.10.15</p>			

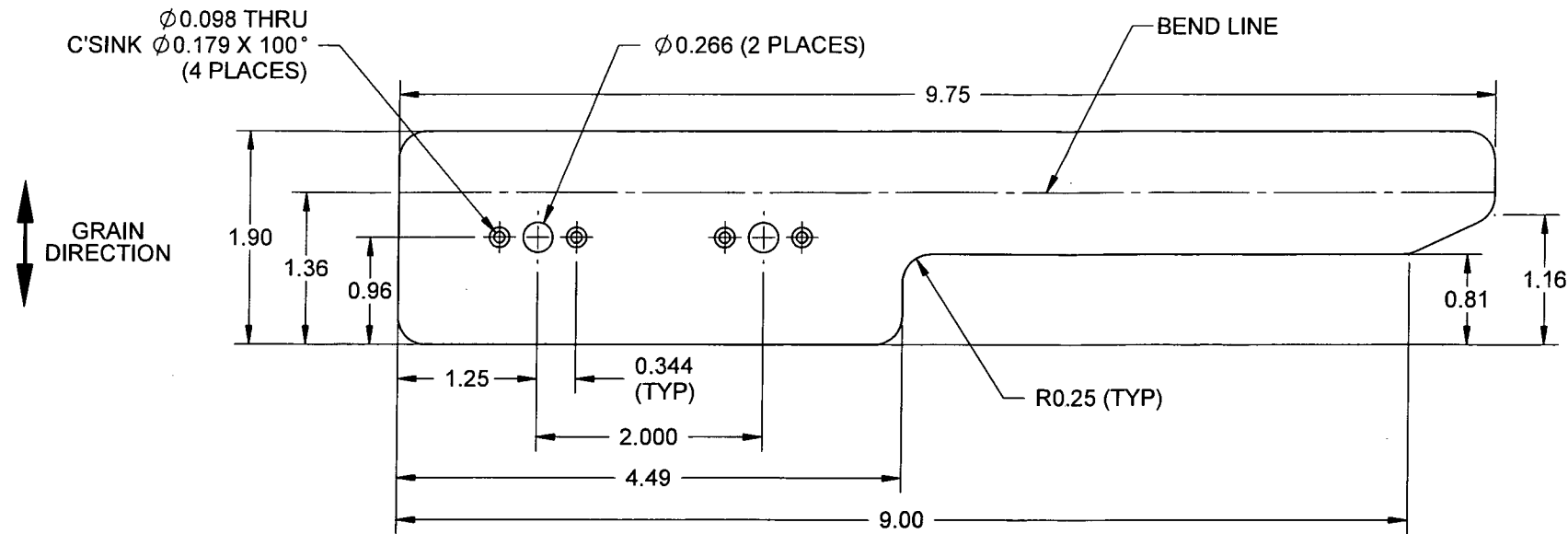
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

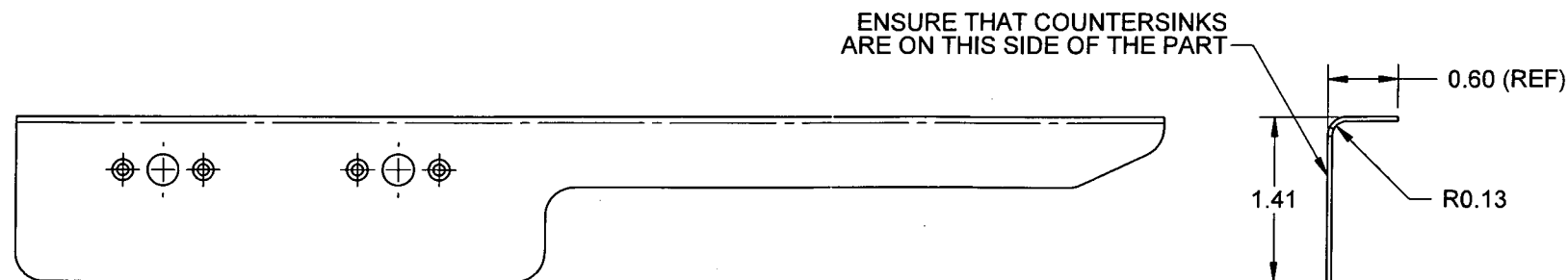
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D3643-1F FLAT PATTERN  
(D3643-2F OPPOSITE)**



**D3643-1 STIFFENER (REPLACES GENEVA P/N G10610-2)  
D3643-2 OPPOSITE (REPLACES GENEVA P/N G10610-1)**

**PRELIMINARY ISSUE**

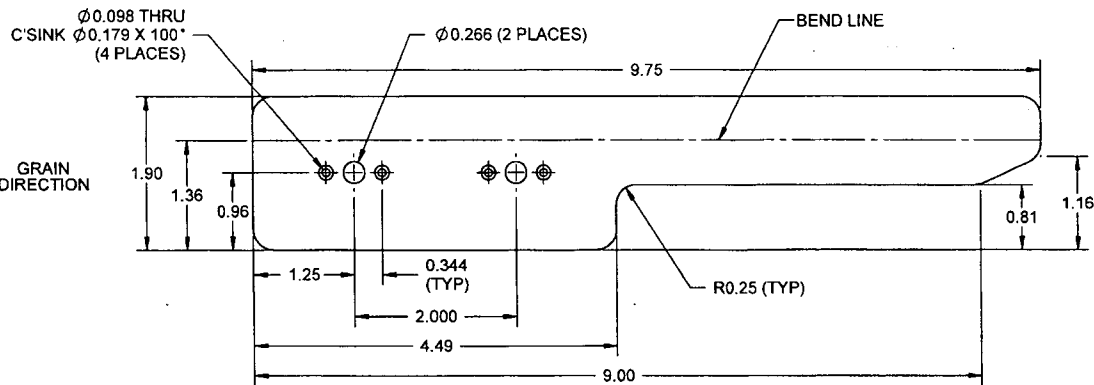
07.09.07 16

**NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.040 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3643-1/-2" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.06 lbs

A	NEW ISSUE; REPLACES G10610	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DTI	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	140	D3643	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		STIFFENER	2:3
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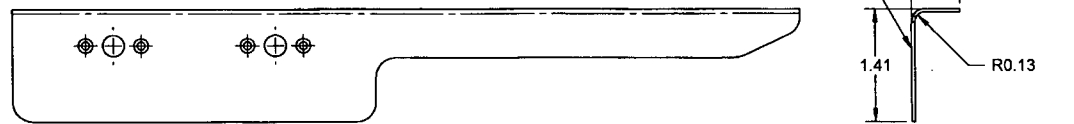




**D3643-1F FLAT PATTERN**  
**(D3643-2F OPPOSITE)**

**REFERENCE ONLY**

ENSURE THAT COUNTERSINKS  
ARE ON THIS SIDE OF THE PART



**D3643-1 STIFFENER (REPLACES GENEVA P/N G10610-2)**  
**D3643-2 OPPOSITE (REPLACES GENEVA P/N G10610-1)**

**RELEASED**  
07.09.07

- NOTES:**
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.040 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.040)
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DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A	
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TITLE STIFFENER		SCALE	2:3
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